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D4466-041
Job Sheet 187089



Part No: D4466-041

Job Qty: 1 pcs

Part Name: Upper Door Assembly, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/18

Job Tracking No:

Due Date: 1/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEETS 1,2,3 IPP Rev:A 11.12.28 new issue DD verf: LL IPP RevB 12.02.10 Per PA2 EC
verified by:DD IPP RevC 12.02.22 per PA3 EC verified by:DD IPP RevD 12.07.03 per Pb1 DD VERF:EC IPP
Rev:E 12.10.09 per dwg revB DD VERF:JLM IPP REV:F 12.12.03 per dwg revC DD VERF:JLM

Ship Via:

7442

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	1 pcs		1/31/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		DAS
							Packaging 1 - 9		3C
							Packaging 1 - 10		9-85
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Suspected Unal	AGAINST DEPARTMENT/PROCESS Container No: S144028 Part: D4466 - 041 Job No: 187089 Serial No/Batch: S144028 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's			
Date : _____		Step #: _____				
Description Work Order Deviation						

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

110	Small Fab - 2 - B4B	1 pcs	1/31/19	0.00	21.98	Packaging 1 - 32	
						Packaging 1 - 33	
						Packaging 1 - 34	
						Packaging 1 - 35	
						Small Fab - 1 - B4B	
						Small Fab - 2 - B4B	
						Small Fab - 3 - B4B	DAS
120	QC 5	1 pcs	1/31/19	0.00	0.00	Small Fab - 4 - B4B	36
						Small Fab - 5 - B4B	9-89
						Small Fab - 6 - B4B	
						Small Fab - 7 - B4B	
						QC 5 - 10	
						QC 5 - 12	
						QC 5 - 16	
130	Packaging 3-1 - Stock - B4B	1 pcs	1/31/19	0.00	0.00	QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 38	
						QC 5 - 42	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	68-6 06 9-89
						Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	DAS 30 9-89
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	

MAR 2 6 2019

MAR 2 6 2019

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	DAC
				Packaging 3 - 35 - B4B	21
140 QC 21 - SA	1 pcs	1/31/19	0.00 0.00	QC 21 - SA - 16	9-88

MAR 26 2019

Part Op 100 - Pick Kit

Descriptions: 110 - Small Fab - Transfer drill hole thru skin as per dwg (see note 10) Dimple for c'sunk rivets.(see note 11-12) Assemble as per dwg and install rivet wet using proseal (see note 8) Seal gaps with proseal as per dwg (see note 9) Proseal 890

B-2 Batch: M138976

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4474-3 <u>93</u>	Splice Block	6 Ea (6 ea)	100-Packaging 1 - Pick Kit	<u>F99109</u>
D4496-041 <u>228</u>	Upper Door Channel Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	<u>F86397</u>
D4499-1 <u>228</u>	Upper Door Channel, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	<u>F95467</u>
D4500-1 <u>229</u>	Bell Door Header, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	<u>F130812</u>
D4501-041 <u>2283</u>	Upper Door Corner Assembly, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	<u>F98252</u>
D4503-1	Upper Door Skin	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	<u>5136458</u>
D4570-3 <u>102</u>	Bracket, LH	1 Ea (1 ea)	100-Packaging 1 - Pick Kit	<u>F86400</u>
MS20426AD3-4	Rivet	20 Ea (20 ea)	100-Packaging 1 - Pick Kit	<u>FM136444-2</u>
MS20426AD3-5	Rivet	16 Ea (16 ea)	100-Packaging 1 - Pick Kit	<u>F4533</u>
MS20426AD4-3	Rivet	39 Ea (39 ea)	100-Packaging 1 - Pick Kit	<u>FM134370-2</u>
MS20426AD4-5	Rivet	26 Ea (26 ea)	100-Packaging 1 - Pick Kit	<u>5083538</u>
MS20470AD4-3	Rivet, Universal Head	42 Ea (42 ea)	100-Packaging 1 - Pick Kit	<u>5680639</u>
MS20470AD4-4	Rivet, Universal Head	6 Ea (6 ea)	100-Packaging 1 - Pick Kit	<u>5106821-1</u>
MS20470AD4-5	Rivet, Universal Head	53 Ea (53 ea)	100-Packaging 1 - Pick Kit	<u>5137218</u>
MS20470AD4-7	Rivet, Universal Head	24 Ea (24 ea)	100-Packaging 1 - Pick Kit	<u>5048900</u>
MS21059L3	Nut Plate	8 Ea (8 ea)	100-Packaging 1 - Pick Kit	<u>5083537</u>
MS21059L3K	Nutplate	10 Ea (10 ea)	100-Packaging 1 - Pick Kit	<u>5131784</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	D4474-3	6	10	0
	D4496-041	1	3	0
	D4499-1	1	1	0
	D4500-1	1	7	0
	D4501-041	1	6	0
	D4503-1	1	0	0
	D4570-3	1	14	0
	MS20426AD3-4	20	4,336	0
	MS20426AD3-5	16	1,940	0
	MS20426AD4-3	39	2,678	0
	MS20426AD4-5	26	1,646	0
	MS20470AD4-3	42	4,849	0
	MS20470AD4-4	6	3,883	0
	MS20470AD4-5	53	761	0
	MS20470AD4-7	24	1,550	0
	MS21059L3	8	152	0
	MS21059L3K	10	386	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					